

Work Order ID 52099

September 16, 2009 10:10:22 AM



Page 1

Item ID:	D3954-7	Accept		Setup	Start	
Revision ID:	<i>K B 09/10/29</i>				Stop	
Item Name:	Ratchet Lug					
Start Date:	09/16/2009	Start Qty:	<i>4 MF</i>	Cust Item ID:		
Required Date:	09/25/2009	Req'd Qty:	<i>2.00</i>	Customer:		
Reference:						

Approvals:	Process Plan:	<i>MF</i>	Date:	<i>09-09-16</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00



Mill Conv

Memo

0.00

09.09.30

15 9.10.1

Conventional Milling Machine

mill to size

110

0.00



Waterjet

Memo

0.00

15 9.10.4

6

FLOW CNC Waterjet

1-Cut as per Dwg D3954

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52099

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Page 2

Item ID: D3954-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Ratchet Lug

Start Date: 09/16/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

of 09.10.5

(6)

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

DT 09/10/05

(6)

Quality Control

140

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____



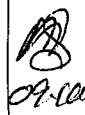
FINISH TIME: _____

09/16/05

*Spray paint yellow
with Bertrend CG1031B*

10 09.10.13

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-10-15	140	Spray paint yellow with Bartrand CG1031B Permanent Change		09/10/28		 09-10-28	 09-10-15

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Work Order ID 52099

September 16, 2009 10:10:22 AM



Page 3

Item ID: D3954-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Ratchet Lug

Start Date: 09/16/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

2) 8016/13

Memo

160



Packaging

Packaging

Identify as per dwg & Stock Location: ST 13910

Memo

0.00

MF 09-10-29

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

09/10/23

MF 09-10-16

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Picklist Print

September 16, 2009 11:17:38 AM

Page 1

Work Order ID: 52099



Parent Item: D3954-7RevA



Parent Item Name: Ratchet Lug

Start Date: 09/16/2009

Required Date: 09/25/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304B1.500X1.500

Purchased

No

100

f

14.2900

2.1053

3.1579



139-10-1

304 bar 1.50 X1.50

M1010 - M1020

See Day 6/10/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

14.29

108381

14.29

110368

110368

W/O:		WORK ORDER CHANGES					
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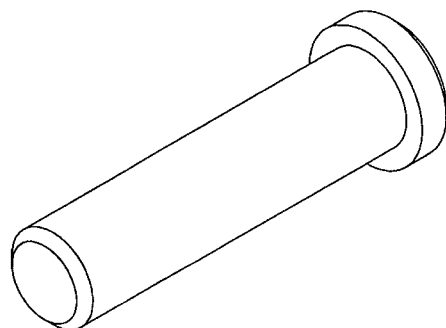
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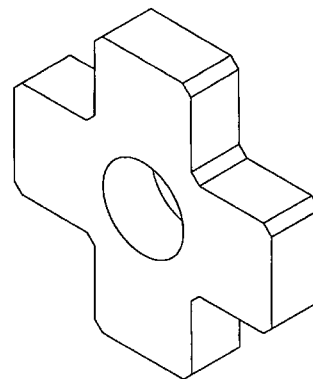
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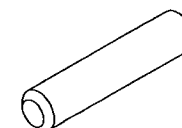


D3954-1 GWT PIN

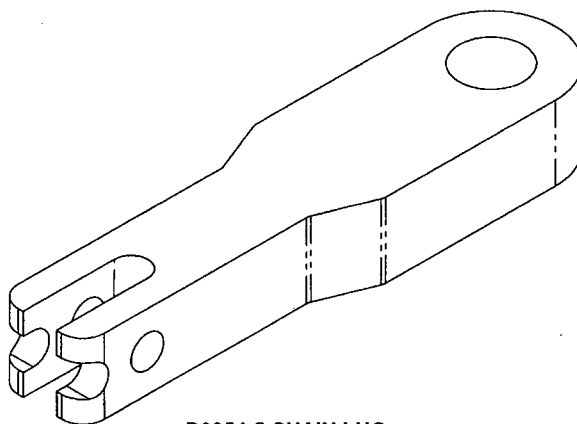
152099



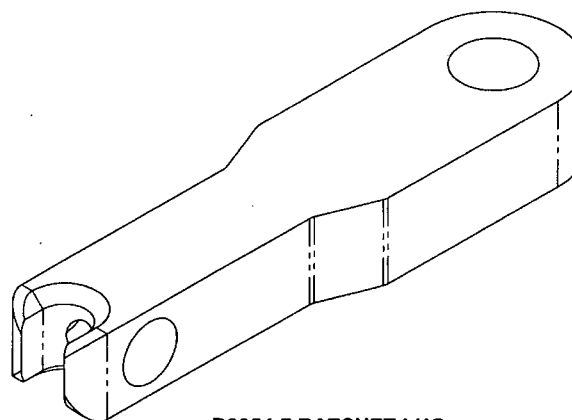
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN






D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

RELEASED
09/05/26

A		NEW ISSUE		AJS		09.05.26			
REV.		DESCRIPTION				BY		DATE	
DESIGN		AJS/DSTOW		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN		AJS							
CHECKED				DRAWING NO.				REV. A	
MFG. APPR.				D3954				SHEET 1 OF 3	
APPROVED				TITLE				SCALE	
DE APPR.		N/A		MISC MACHINED PARTS GWT KIT				NTS	
DATE		09.05.26		<p>COPYRIGHT © 2009 BY DART AEROSPACE LTD</p> <p><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small></p>					

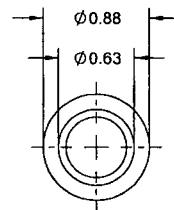
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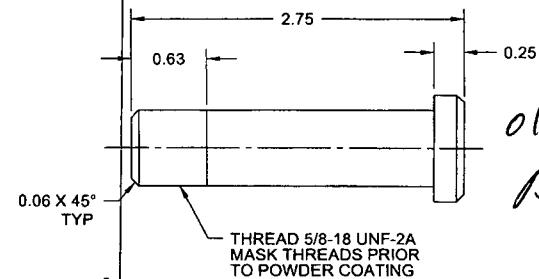
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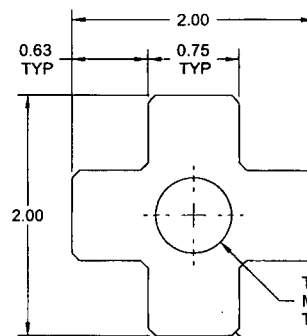


D3954-1 GWT PIN



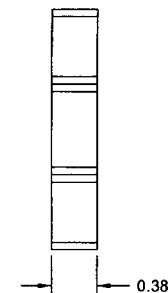
ok by M. V. Steel
ASS 01.09.28

52099



D3954-3 GWT KNOB

THREAD 5/8-18 UNF-2B THRU
MASK THREADS PRIOR
TO POWDER COATING



NOTES:

1) MATERIAL -1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
PER AMS 5513 OR AMS 5524
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
01/16/12

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	
DATE	09.05.26	<small> COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

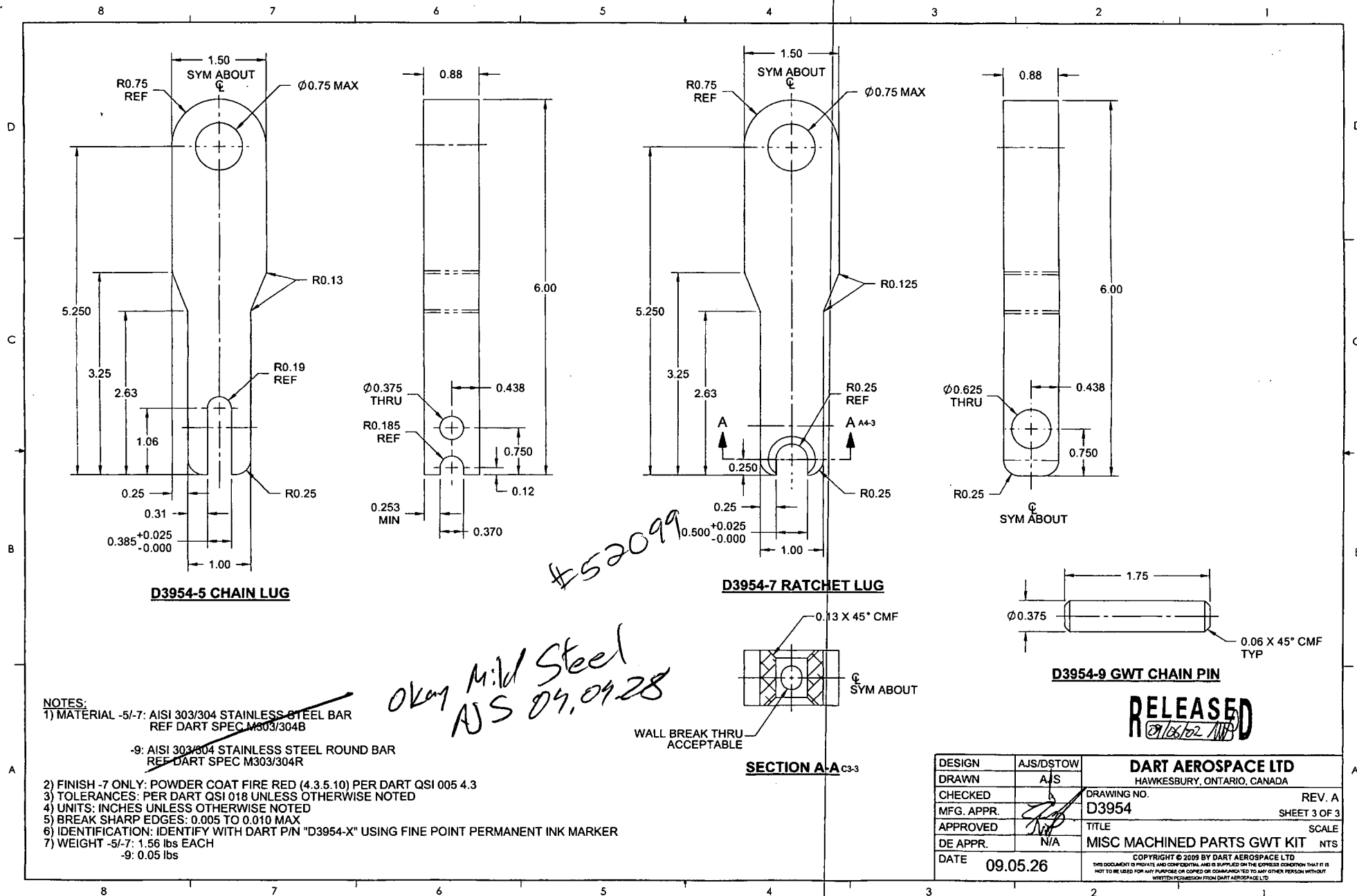
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